Work Order ID 97500 *97500* Page 1 Thursday, February 21, 2013 12:57:18 PM D4092-1 Item ID: Accept *N900040100* **Revision ID:** Item Name: Maintenance Step **Start Date: Start Qty: 12.00** 2/25/2013 **Cust Item ID:** Required Date: 3/15/2013 Req'd Qty: 12.00 **Customer:** Reference: Date 3022/ Tooling: **Process Plan:** Approvals: Date: Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description Qty Qty **Run Hours** Code Number Stamp **Draw Nbr Revision Nbr** D4092 В 100 Cut blanks as per folio 0.00 30.250 *100* Bandsaw 0.00 Memo Jeaspa Bandsaw 110 0.00 *110* HAAS 1 0.00

13/03/19

Deburr

Memo

Dwg Rev: Folio rev:_

Mill as per Dwg and Folio FA935

HAAS CNC vertical machine #1

											DQA:	Date:	£ ,
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	AANCE / UI	PDATE	·		<u> </u>
									<u></u>		QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIR Olde	-1.		· · · · ·			Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	Vo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]	Therm	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	۷o.					Work Order Update	╛╽		Large Fab	Composite		Supplier	
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Root		Date	Step	Qty		ption of work order update or Non-conformance	1	nitial iief Eng		scription	Sign & Date	Verification	QC Inspector
Cause	-	Date	Step	Qty		or Non-comormance	1	ilei Liig	Des	cription	Date	Vermeation	QC IIISPECTOI
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Supplier	\vdash												
Training	Н		į		1								
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Landing Gear						General					_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
l .					~ /a]		1		1]	A-1	T

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	Centre Not Concentric to O/S	BOM/Route	H	Hardware	Over/Under tolerance		Temperature/Cure
Γ	Cracks	Broken/Damaged	11	nspection Incomplete	Part Incorrect	L	Weld
	Crushed/Crimped.	Burrs	I	nstructions Incomplete/Unclear	Part Lost/Missing	Ĺ	Wrong Stock Pulled
ſ	Cuffs	Contamination		Maintenance	Part Moved		
ſ	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
Γ	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
Γ	Wave/Twist in Tube	Folio	П	Outside Dimensions			

Work Orde Thursday, Febru				*97500*									Page 2	•
Revision ID:	D4092-1 Maintenance S	Step		Accept		*N9000	740	1100* Setup			Start Stop	*N:	S1* S2*	
	2/25/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12			Cust Item IE Customer:) :					I VI	. 7/	
Approvals:		in:				Dat	te:		R	lun	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 120 *120 CC Quality Control	D	Operation Description QC2- Inspect parts off m Memo	achine FAI/FAIB	Set U Run 0.00	Jp/ Hours	Tool ID 13103/19	Tool#		Accept Qty		, I	Reject Number	Insp. Stamp	
130 *130* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00					N				0An 33 15-03	10
140 *111		Chemical Conversion Co	oat per QSI005 4.1	0.00					17		14B	? 13 ל	320)

Hand Finishing

												DQA:	Date	e:	т 1
NCR:	Yes	/ No			•	WORK ORDER NON-C	COI	NFORM	AANCE / UPD	DATE					
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Work Ord	or:					DISPOSITION				AGAINST DI	EF	PARTMENT	PROCESS		
work Ord	ег.					Rework	1		Skid-tube	Crosstube	٦		Water Jet	\neg	Engineering
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	•					Use-as-is	1 1		noforming	Finishing	┪		e/Packaging	ᅵ	Other
NCR f	No.					Work Order Update	1		Large Fab	Composite	٦		Supplier		
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Root					1	ption of work order update	1	nitial	Acti		İ	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	4	Date	Verification	\Box	QC Inspector
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	\sqcup	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
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	Inspection Strip in Tube					Cut Too Short	Misread				Power Loss/Surge			Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Ord Thursday, Febr				*97				Page 3	
Item ID: Revision ID: Item Name:	D4092-1 Maintenance S	Step		Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	2/25/2013 : 3/15/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:	<u>-</u>	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 155 *155* HandFinish Hand Finishing	T D	Operation Description Wing Walk as per dwg Q	S1005 4.4 Batch / 24	Set Up/ Run Hours 550,00	Tool ID Tool #	Plan Acce Code Qty	Qt	y N	Reject Insp. Number Stamp
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo		0.00		12x	J	My	L13/03/Q1
170 *17 0* Packaging		Identify as per dwg & Sto	ck Location:	0.00		· 		// ~3/) <u>/3/21</u> [12]

Packaging

			DQA:	Date:	5
NCR: Yes / No	WORK ORDER NON-CON	FORMANCE / UPDATE			
			QA Closed:	Date:	
Work Order:	DISPOSITION	AG	AINST DEPARTMENT/PRO	OCESS	
Work Order:	Rework	Skid-tube Cros	sstube	Vater Jet	Engineering[
Part No.	Scrap	Machining Sma	all Fab Prod. Er	ng. Coor.	Quality

Work Order Update

Description of work order update

or Non-conformance

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Broken/Damaged

Use-as-is

Initial

Chief Eng

FAULT CATEGORY

Outside Dimensions

			QA Closed:	D	ate:								
	AGAINST DEPARTMENT/PROCESS												
	Machining Sma	stube II Fab shing oosite		Water Je d. Eng. Coor e/Packaginį Supplie		Engineering Quality Other							
nitial	Action		Sign &	·									
ief Eng	Description		Date	Verificati	on	QC Inspector							
T CATE	GORY					•							
Grain			Ovalized			Pressure/Forced							
Hardwa	aro	-	Over/Under	tolorance	\vdash	Temperature/Cure							
	ion Incomplete	-	Part Incorre		-	Weld							
	tions Incomplete/Unclear	-	Part Lost/M		\vdash	Wrong Stock Pulled							
	enance		Part Moved	22111B	L	1ong stock i diled							
Mislabe			Positioned V	Vrong									
Misrea			Power Loss/	-		Other							
Offset		L	J	5	_	· · · · · · · · · · · · · · · · · · ·							
	Calibration												
Out of	Sequence												

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

NCR No.

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Date

Step

Centre Not Concentric to O/S

Qty

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

Work Ord Thursday, Febr				*97500*								Page 4
Item ID: Revision ID: Item Name:	D4092-1 Maintenance	Step		Accept	*N900	040	100)* s	_	Start Stop		S1* S2*
Start Date: Required Date: Reference:	2/25/2013 : 3/15/2013	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:						
Approvals:	Process Plan:		Date:	Tooling:	Da	ıte:	_	F	Run	Start	*N	R1*
••	QC:		Date:	SPC (Y/N):		ıte:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Leject Iumber	Insp. Stamp
180 QC Quality Control		Memo		0.00					MCZ	13 -	03-7	3.03.2

												DQA:	Date:	· ·
NCR:	Yes	/ No					WORK ORDER NON-C	COL	VFOR	ANCE / UPD		0.4.6!		
						_						QA Closed:	, Date:	
Work Ord	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
				<u> </u>		١	Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part	۷o.						Scrap		l	Machining	Small Fab		d. Eng. Coor.	Quality
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NCR	No.						Work Order Update]		Large Fab	Composite		Supplier]
Root			<u> </u>	1. 1	Dosc	rin.	tion of work order update		nitial	Actio	an an	Sign &	· · · · · · · · · · · · · · · · · · ·	
Cause		Date	Step	Qty	Desc		r Non-conformance	1	ief Eng	Descrip		Date	Verification	QC Inspector
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	<u> </u>	Cracks	x				Broken/Damaged	\vdash	1 '	on Incomplete		Part Incorred	<u> </u>	Weld
	_	Crushed/	Crimped.		-	_	Burrs	-	4	ions Incomplete/Ur ·	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
	<u> </u>	Cuffs			-	_	Contamination	_	Mainte			Part Moved		
	<u> </u>	Heat Trea			-	4	Countersink	<u> </u>	Mislabe			Positioned V	_	7
	<u> </u>	Inspection	•	Tube	-	_	Cut Too Short	-	Misread			Power Loss/	Surge	Other
	_	Ripples in				4	Drill Holes	\vdash	Offset	- 44				
	<u></u>	Torque W			າ ∤		Drawing	_	-1	Calibration				
	1	Turning S	equence			ı	Finish	1	Out of !	Sequence				

Outside Dimensions

Wave/Twist in Tube

Thursday, February 21, 2013 12:57:18 PM

Work Order ID:

97500

Parent Item:

D4092-1

Parent Item Name:

Maintenance Step

Start Date: 2/25/2013

Required Date: 3/15/2013

Start Qty: 12.00

Required Qty: 12.00

Comments:

Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD 639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

	639 JLM VERIFIE	ED BY:DD											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	792.8689	2.5	31.578947	# · · · · · · · · · · · · · · · · · · ·		
Extrusion (HPK)									<u>ه- ـ ـ = ـ ـ ـ ـ .</u>			- 63	(-7
				Location		Loc Oty	<u>Lo</u>	c Code			, ,	2	19
				MAT007		792.86894							
				8020 0 8323	5	782.5725			31	.579			
				8323	_	10.29644							

									DQA:	Date: _	
NCR: Ye	es / No			\	WORK ORDER NON-C	CONFORI	MANCE / UP		QA Closed:	Date:	
Work Order				:	DISPOSITION			AGAINST DEI	PARTMENT	/PROCESS	
Work Order	·				Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part No	0				Scrap Use-as-is		Machining noforming	Small Fab Finishing		d. Eng. Coor.	Quality Other
NCR No	0	······································			Work Order Update		Large Fab	Composite	necy ster	Supplier	
Root				Description	on of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or l	Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data				*							
Equip/Tooling											
Operator											
Material								!			
Setup											
Other								:			
Process	7										
Supplier											
Training					•				<u>'</u>		
Unapproved											
					F	AULT CATE	GORY				

Landing	Gear	General	 _		
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong `	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

DART AEROSPACE LTD	Work Order:	97500
Description: Maintenance Step	Part Number:	D4092-1
Inspection Dwg: D4092 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	+/-0.030	30,060	~		Tupe	ST - 10
0.19	+/-0.030	0.188	~		vern	FT-4
1.25	+/-0.030	1.250	<u></u>			
1.38	+/-0.030	1.377				
0.25	+/-0.030	0-245	_			
R0.25	+/-0.030	0,25	/			
2.50	+/-0.030	2.499				
Ø0.201	+0.005/-0.001	0.201	<i></i>			
0.30	+/-0.030	0.300				
4.78	+/-0.030	4.780				·
1.69	+/-0.030	1.690				
2.6996	+/-0.030	2.96				
0.030	+/-0.010	0.027	_		depthyange	RT-6
0.20	+/-0.030	0.90				
0.50	+/-0.030	0.484	~			
0.035	+/-0.010	0.027				
0.390 x 100°	+/-0.010 x 0.5°	0.400	/			
1.500	+/-0.130	1.500				
0.50	+/-0.030	0.500				
1.25	+/-0.030	1.250				
0.69	+/-0.030	0.695				
0.38	+/-0.030	0.366				
0.69	+/-0.030	0.692		-		

D.a				
Measured by: ET.	Audited by:	TEC .	Preliminary Approval:	
Date: 13.03-16	Date: 12.03.19		Date:	

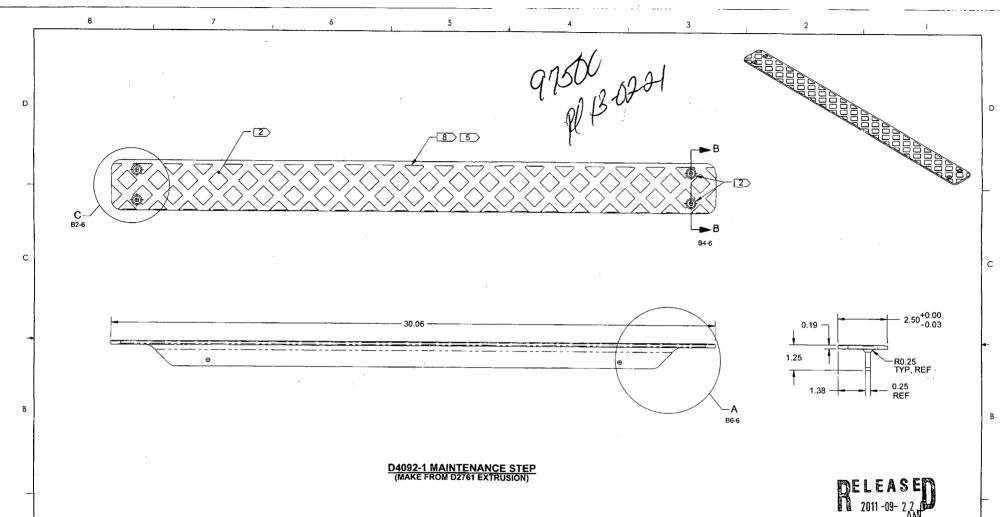
Rev	Date	Change	Revised, by	Approved
A	12.05.15	New Issue	KJ del	6/1
			7)	71

, s ."												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-O	CON	VFOR	MANCE / UPDATE		-	5 .	
							·					QA Closed:	Date:	
Vork Ord	er:						DISPOSITION			AGAI	NST DE	PARTMENT/	PROCESS	
	Part No.						Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR I	No.						Work Order Update			Large Fab Compo	site]	Supplier	
Root					Des	cri	otion of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty			or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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rocess upplier raining napproved										. !)	/	,	-	No. 1
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Landi	ng (Gear					General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	\vdash	Ripples in Torque W		Sytrucia	n	-	· ·	-	Offset	Calibration				
		Turning Se			T1	-	Drawing Finish	\vdash	4	Sequence		***************************************		
		Lining 20	equence			1	Liman	1	Journ.	ocquence				

Outside Dimensions

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Wave/Twist in Tube



NOTES:
1) MATERIAL: MAKE FROM D2761 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
6) IDENTIFICATION: IV/A
7) WEIGHT: 1.97 lbs
8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45 ° PATTERN 0.38 APART

DESIGN RF DART AEROSPACE USA, INC. DRAWN RF KENT, WA DRAWING NO. CHECKED REV. B D4092 MFG. APPR SHEET 5 OF 6 APPROVED TITLE SCALE DE APPR. MAINTENANCE STEP ASS'Y DATE 11.07.27

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HOT TO BE USED FOR MAY PURPOSE OR COMPANION TO TO ANY OTHER PERSON WITHOUT
WRITTEN PERSONS PRODUCED LA REPORTS OF ANY OTHER PERSON WITHOUT
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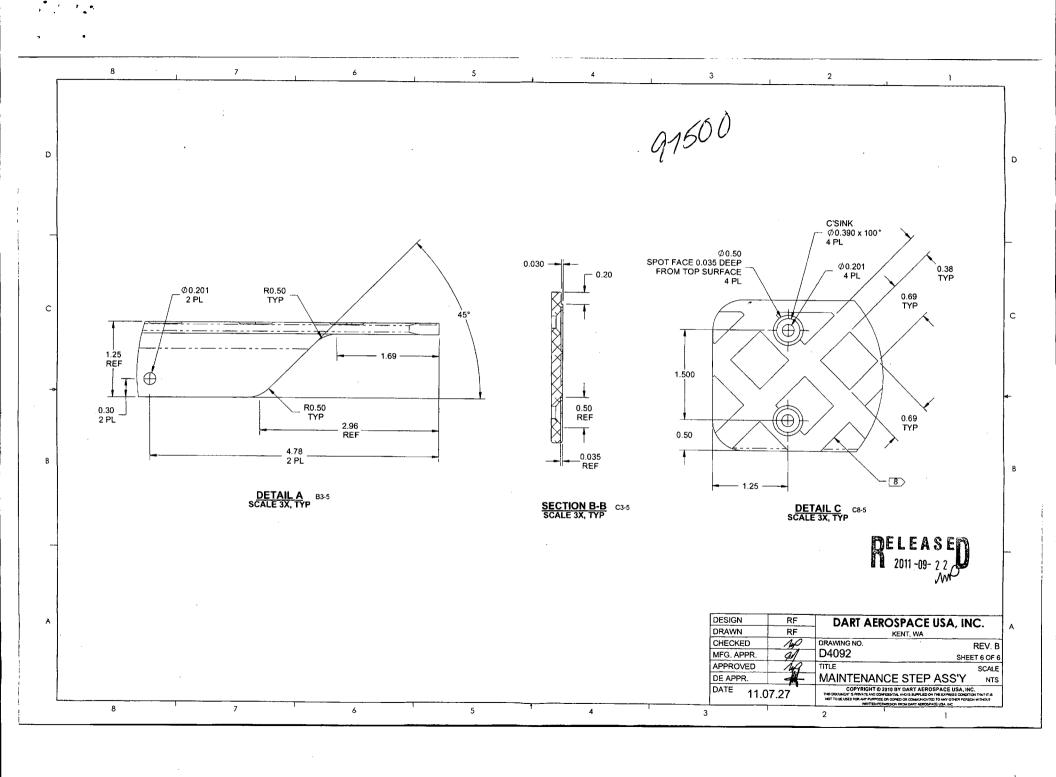
NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

NCR: Y	es / No				WORK ORDER WON-	CONFOR	VIAITCE / OF		QA Closed:	Date	:	
Work Orde	·r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
VVOIR OIGE					Rework	7 [Skid-tube	Crosstube		Water Jet	Engineering	
Part N	0.				Scrap	† 	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
			·	· · · · · · · · · · · · · · · · · · ·	Use-as-is		moforming	Finishing		re/Packaging	Other	
NCR N	0				Work Order Update]	Large Fab	Composite		Supplier		
Root				Descri	tion of work order update	Initial	Ac	tion	Sign &	/		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator				•					1			
Material												
Setup												
Other												
Process												
Supplier												
Training							Ì				·	
Unapproved										<u> </u>		
		-				AULT CATE	GORY					
Landir	ng Gear			_	General				7	_	-	
	Bending				Bend	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw			Over/Under	-	Temperature/Cure	
	Cracks			<u> </u>	Broken/Damaged	\vdash	tion Incomplete		Part Incorre	_	Weld	
	Crushed/	Crimped.			Burrs	├	tions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Maint	enance		Part Moved			
	Heat Trea	it			Countersink	Mislab	eled		Positioned \			
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss,	/Surge	Other	
[Ripples in	Bend			Drill Holes	Offset						
Ī	Torque W	aves in E	extrusio	n [Drawing	Out of	Calibration					
Ī	Turning S	equence			Finish	Out of	Sequence					
1	Wave/Tw	ist in Tul	эe		I_{Folio}	Outsid	Outside Dimensions					

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NCR:	Yes	/	No

										•	DQA:	Date:	
NCR: \	es.	/ No					WORK ORDER NON-C	ON	IFORI		_		
											QA Closed:	Date:	
Vork Orde	·r·						DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
VOIK OTGE	-						Rework			Skid-tube Crosstube		Water Jet	Engineering
Part N	lo.						Scrap			Machining Small Fab	Prod	l. Eng. Coor.	Quality
	-						Use-as-is		Thern	noforming Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo						Work Order Update]		Large Fab Composite		Supplier	
Root		 .			Des	crir	otion of work order update		nitial	Action	Sign &		
Cause		Date	Step	Qty			r Non-conformance		ief Eng	Description	Date	Verification	QC Inspector
oc/Data						-							
quip/Tooling	.	٠,			· m,							,	
perator													
laterial													
etup													
ther					•			-					
rocess	\Box												
upplier		•								·	•		
raining													,
napproved		_					,						
								AUL	T CATE	GORY	· ·		
Landi	ng G	iear					General		1		**************************************		·
		Bending					Bend		Grain		Ovalized		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s		BOM/Route	L	Hardwa	 	Over/Under		Temperature/Cure
	Ш	Cracks					Broken/Damaged	<u> </u>	4 '	ion Incomplete	Part Incorred	-	Weld
		Crushed/0	Crimped.				Burrs		1	tions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination		1	enance	Part Moved		
	Heat Treat						Countersink		Mislab	-	Positioned V		1
		Inspection	-	Tube			Cut Too Short		Misrea	d <u> </u>	Power Loss/	Surge	Other
		Ripples in					Drill Holes		Offset				
		Torque W	/aves in E	xtrusio	n	L	Drawing	_	4	Calibration			
	Turning Sequence						Finish	L	Out of	Sequence			

Outside Dimensions

Wave/Twist in Tube